

Work Order ID 52153

Thursday, September 17, 2009 8:10:18 AM

Page 1

Item ID: D209-669-014

Accept

Revision ID: B

Item Name: Skidtube RH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

899-17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D209-669-014

Rev B

DSI 9450

Rev A

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D209-669-014 CHG003

Sorted

110

0.00



Packaging

Pick Kit

Memo

0.00

Packaging

9/30/09 ①

52109

Work Order ID 52153

Thursday, September 17, 2009 8:10:18 AM

Page 2

Item ID: D209-669-014

Accept

Revision ID: B

Item Name: Skidtube RH

Start Date: 9/18/2009 Start Qty: 1.00

Required Date: 10/9/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

275 or less

Quality Control

+6 9

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-014
Location: _____

P 9/14/06

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/06
MF
09-10-06

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Work Order ID: 52153

Parent Item: D209-669-014RevB

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/18/2009

Required Date: 10/9/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D209-669-043RevB Manufactured No



Replacement Skidtube

Warehouse Loc Qty Loc Code

Location

Premier

Mezz

22797

39205

39206

3

1

1

1

110

Each

3.0000

2.0000



52153

9/18/09

D2917-2RevB Manufactured No



Saddle RH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FG

51328

3

3

110

Each

3.0000

2.0000



52129 9/18/09

D2918-2RevB Manufactured No



Saddle RH

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43138

51330

3

1

2

52133

Picklist Print

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Thursday, September 17, 2009 8:10:17 AM

Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-51A		Purchased	No			110	Each	354.0000	8.0000			
---------	--	-----------	----	--	--	-----	------	----------	--------	--	--	--



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

354

110328

2

111635

102

112314

100

112489

100

112641

50

D2570RevB

Manufactured No

110

Each

139.0000

24.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

47246

15

Main Warehouse

ST36

124

50356

124

351519

24x

2/5 09/09/30

2/5 09/09/30

*

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Shop Packet Print

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Picklist Print

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Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L4		Purchased	No			110	Each	8,148.000	24.0000			
<div style="display: flex; justify-content: space-between;"> <div style="text-align: right;"> <p><i>EP 09/09/30</i></p> </div> </div>												

Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	8148	
107499	5	
108145	4	
110450	1	
110507	184	
111827	5996	
112314	1893	
15924	0	
7690	24	
8182	41	

AN5-36A

Purchased

No

110

Each

555.0000

4.0000

Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST	555	
109545	11	
110467	7	
110731	4	
112243	20	
112314	463	
112385	50	

Picklist Print

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Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S

AN960JD516

Purchased

No

110

Each

1,097.000

8.0000



Washer



Ep 09/09/30
B M 112794 (8+)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1097

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

247

112314

500

S

MS21042L5

Purchased

No

110

Each

1,279.000

4.0000



Nut



Ep 09/09/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1279

110382

10

111636

269

112314

1000

4

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Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH



Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-7A  Bolt		Purchased	No			110	Each	201.0000	16.0000			

CP 09/09/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

111668

1

112314

50

112385

50

112641

100

10
6

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Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416

Purchased

No

110

Each

8,313.000

32.0000



Washer



Ep 09/09/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8313

102929

2

105906

4

106277

2

107321

23

107939

114

108161

553

108827

31

109249

69

110523

340

111279

101

111916

2187

112314

4887

16941

0

32

D2929RevB

Manufactured

No

110

Each

15.0000

2.0000



Spacer



Ep 09/09/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

43376

15

B 52243

(1x)

1

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Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S D2930RevB 		Manufactured	No			110	Each	11.0000	2.0000		<i>Ep 09/09/30</i>	
Spacer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

43378

11

B52249 (2x)

S D3405-041RevB 		Manufactured	No			110	Each	10.0000	1.0000		<i>Ep 09/09/30</i>	
Lug Assembly												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

51254

10

B51673 (1x)

S AN4C47A 		Purchased	No			110	Each	222.0000	4.0000		<i>Ep 09/09/30</i>	
Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

222

110847

4

112431

18

112489

100

112641

100

4

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Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21043-4		Purchased	No			110	Each	1,397.000	5.0000			
<div style="display: flex; align-items: center;"> <div style="margin-left: 20px;"> <p><i>Ep 09/09/30</i></p> </div> </div>												

Nut

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST	1357	
111819	35	
112243	22	
112314	1000	
112492	300	

D3405-043RevB Manufactured No



Lug Assembly

110 Each 12.0000 1.0000



Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	12	
46589	1	
46863	1	
51255	10	

351652

(1x)

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Thursday, September 17, 2009 8:10:18 AM

Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S D3407-041RevE Manufactured No

110

Each

35.0000

1.0000



Tow Ring

9/30/09/30

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

3

35780

3

Main Warehouse

ST

1

48356

1

Main Warehouse

ST464

31

51659

31

S D3456-1RevA

Manufactured No

110

Each

232.0000

1.0000



Washer

9/30/09/30

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

7

25701

7

Main Warehouse

ST

225

46752

25

51653

200

Picklist Print

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Work Order ID: 52153



Parent Item: D209-669-014RevB



Parent Item Name: Skidtube RH

Start Date: 9/18/2009

Required Date: 10/9/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3417-5RevE

Manufactured

No

110

Each

152.0000

2.0000



Washer



9/20/09/30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

152

51649

152

2

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DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32153

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

A	NEW ISSUE	AJS	09.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

5.0 PARTS LIST

52153

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1			D3405-041	LUG ASSEMBLY
51	8	8	4	4			AN4C47A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21043-4	NUT
54			1	1			D3405-043	LUG ASSEMBLY
60	1	1	1	1			D3407-041	TOW RING ASSEMBLY
61	1	1	1	1			D3456-1	WASHER
62	1	1	1	1			MS21043-4	NUT
63	2	2	2	2			D3417-5	WASHER

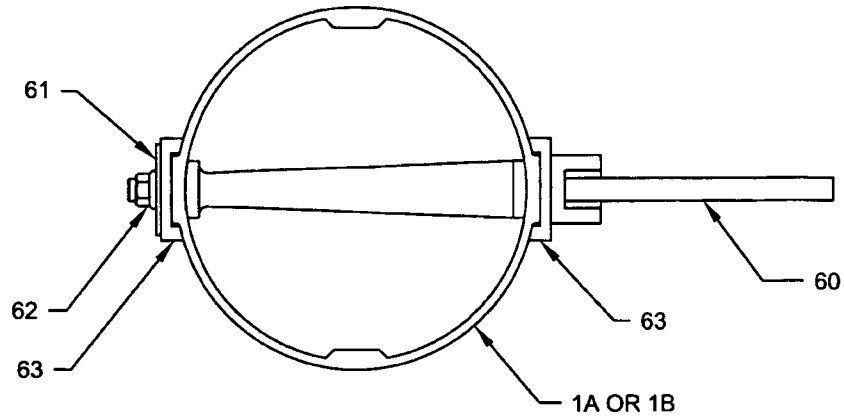
WAS:

50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	GHW LUG
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

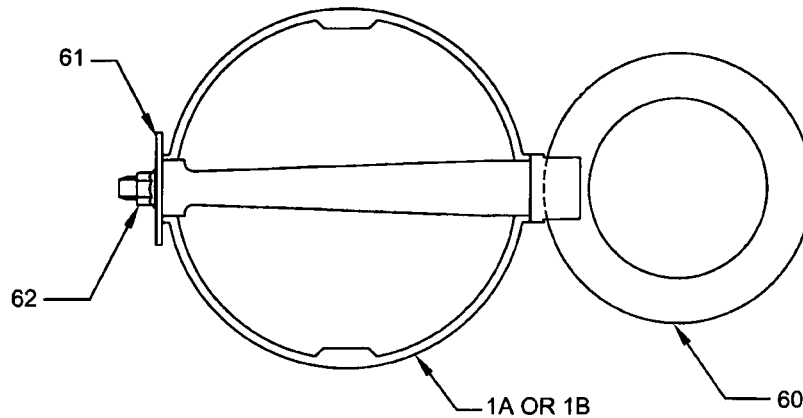
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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52153
INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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